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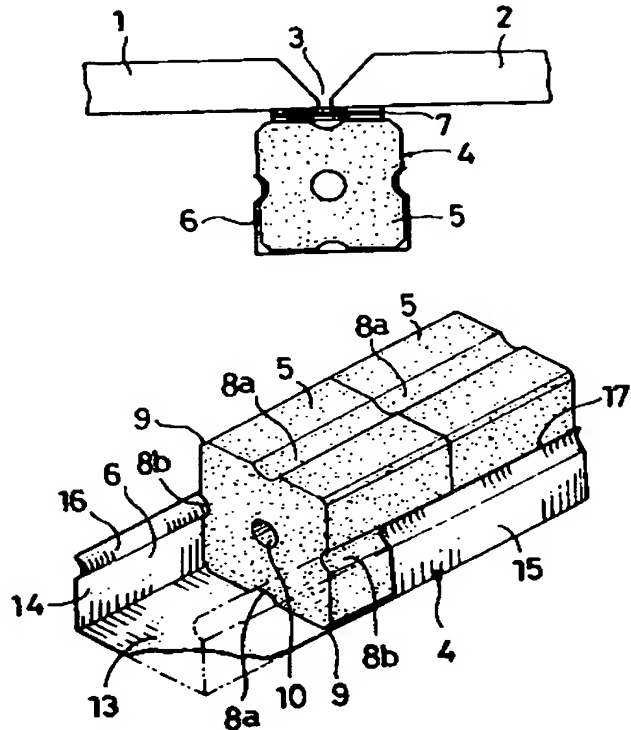
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TITLE : PENETRATION WELDING METHOD  
AND BACKING STRIP FOR  
PENETRATION WELDING



ABSTRACT : PURPOSE: To form a stable penetration bead even in a narrow root gap by constituting a backing strip of a casing and plural ceramic blocks housed in the casing and interposing further a glass fiber sheet between the groove and the backing strip.

CONSTITUTION: A backing block 5 has approximately a square section and hollow grooves 8a, 8a, 8b, 8b respectively extending longitudinally are formed on the top, bottom, right and left side faces thereof. A pair of the grooves 8a are formed to the same size and a pair of the grooves 8b are formed to the size slightly larger than the grooves 8a so that the size of the hollow grooves can be changed according to the various sizes of the root gap of the groove 3. A casing 6 has a bottom part 13 and both side parts 14, 15 and projecting parts 16, 17 for engagement which hold the block 5 by fitting into the grooves 8a, 8b provided on both side surfaces of the block 5 are provided to the parts 14, 15. A sheet material 7 of glass fibers is interposed between the groove 3 and a backing material 4.

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